



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G13231-3G
Job Sheet 172399



2/16/18

Part No: RBW6305G13231-3G

Job Qty: 3 ea

Part Name: Gimball Carbon Seal Installer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G13231-3G Rev B IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		4/16/18	0.00	0.00	Purchasing		AT 170561
110	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging2		AT 180561
120	QC	3 pcs		4/16/18	0.00	0.00	QC6		38
130	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging3		8-58
140	QC21-FG	3 Ea		4/16/18	0.00	0.00	QC21		MAY 02 2018 GA 163

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 035054 MANUFACTURE RBW6305G13231-3G AS PER
Descriptions: DWG -Certificate of conformity is required

FEB 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G13231-3GP	Gimball Carbon Seal Installer	3 (1 ea)	100-Purchasing	5067427

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G13231-3GP	3	0	0

Part Specifications

Specifications could not be found.

Plex 2/16/18 9:25 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

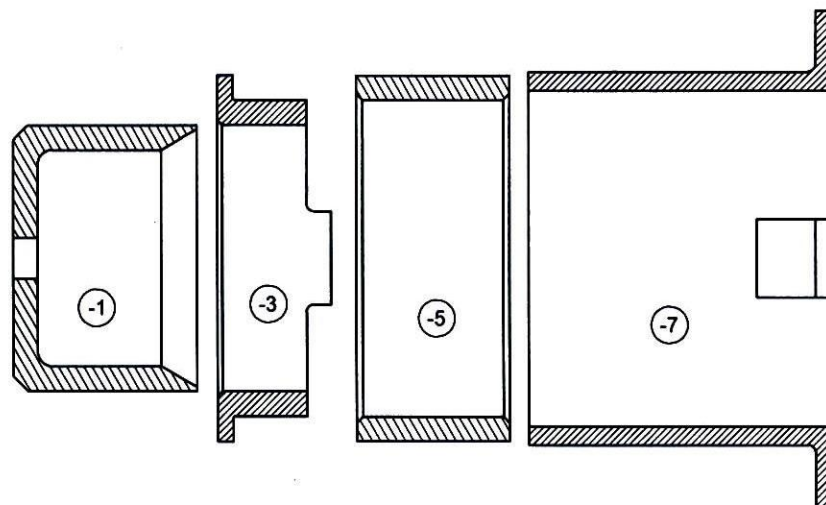
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																
Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval																																																																															
Description Work Order Deviation		Disposition																																																																																
PART NO: RBW6305G13231-3G Serial No/Batch: S067425 Revision: _____ Operation: Packaging Change No: _____ Mig Date: 05/01/18 Job No: 172399 S067425 Container No: _____ DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Gimball Carbon Seal Installer																																																																																		
Completed By _____																																																																																		
Lead hand / Supervisor Approval Verification _____																																																																																		
QC / QA Coordinator Approval _____																																																																																		
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td>☐ Positioned Wrong</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> </tr> <tr> <td>☐ Outside Dimensions</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> </tr> <tr> <td>☐ Over/Under tolerance</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> </tr> <tr> <td>☐ Part Incorrect</td> <td></td> <td></td> </tr> <tr> <td>☐ Part Lost/Missing</td> <td></td> <td></td> </tr> <tr> <td>☐ Part Moved</td> <td></td> <td></td> </tr> <tr> <td>☐ Drawing</td> <td></td> <td></td> </tr> <tr> <td>☐ Finish</td> <td></td> <td></td> </tr> <tr> <td>☐ Misread</td> <td></td> <td></td> </tr> <tr> <td>☐ Turning Sequence</td> <td></td> <td></td> </tr> </table>			☐ Positioned Wrong	☐ Cut Too Short	☐ Mislabeled	☐ Outside Dimensions	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Over/Under tolerance	☐ Drill Holes	☐ Misaligned/off center	☐ Part Incorrect			☐ Part Lost/Missing			☐ Part Moved			☐ Drawing			☐ Finish			☐ Misread			☐ Turning Sequence		
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OTHER : _____																																																																																		

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D BOM INFORMATION -1, -3, -5 & -7, CH'D -7 ENGRAVE NOTES PER R.W.	5/6/11	RJC	RW
B	CH'D TOOL NAME WAS GIMBAL CARBON SEAL INSTALLER IS TOOL, GIMBAL CARBON SEAL INSTALLER TO MATCH PARTS MANUAL.	11/1/13	RJC	RW



NOTES

1. ALSO SOLD WITH KIT RBW6305G01531-3G, BOX ONE RBW6305G19631-3G.

RED BARN MACHINE	
TITLE TOOL, GIMBAL CARBON SEAL INSTALLER	
DWG NO. RBW6305G13231-3G	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 METRIC REF. .XXmm ± .1mm XX ± .01 FRACTIONS ± 1/32 X ± 1/8 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 2-4-11
SHEET 1 of 5	

ASSY QTY	ASSY #	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	CAP	6061 RND. BAR	Ø3-1/2 x 2-3/8	2
			-3	1	TOP RING	6061 RND. BAR	Ø4-3/4 x 1-7/8	3
			-5	1	RING	6061 RND. BAR	Ø4-3/4 x 2-3/8	4
			-7	1	BASE	6061 RND. BAR	Ø6-1/2 x 4-7/16	5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				



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PURCHASE ORDER **PO039084**

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
Line Item Note job# 172405											
23	RBW6305G13731-3GP			Gimball Carbon Seal Remover As Per Dwg RBW6305G13731-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$362.28/Ea	\$1,086.84
							✓ 3x			AT 18/04/26	
Line Item Note job# 172401											
24	RBW6305G13231-3GP			Gimball Carbon Seal Installer As Per Dwg RBW6305G13231-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$984.42/Ea	\$2,953.26
							✓ 3x			AT 18/05/01	
Line Item Note job# 172399											
25	RBW6305G14031-3GP			Gimball Carbon Seal Remover As Per Dwg RBW6305G14031-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$639.24/Ea	\$1,917.72
							✓ 3x			AT 18/05/01	
Line Item Note job# 172397											
26	RBW6305G14331-3GP			Upper Module Lip Seal Installer As Per Dwg RBW6305G14331-3G Rev. 1	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$758.42/Ea	\$2,275.26
							✓ 3x			AT 18/05/01	
Line Item Note job# 172382											
27	RBW6305G18251-3GP			Guide Pumps/Ecs Drive Quill Seal Housing Installer As Per Dwg RBW6305G18251-3G Rev. A	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$132.32/Ea	\$396.96
							✓ 3x			AT 18/04/16	
Line Item Note job# 172381											
28	RBW6305G17631-3GP			Tool Pump 1-2-3 Drive Quill Lip Seal Remover As Per Dwg RBW6305G17631-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$496.30/Ea	\$1,488.90
							✓ 3x			AT 18/04/26	
Line Item Note job# 172378											
29	RBW6305G17931-3GP			Tool Pump 1-2-3 Drive Quill Lip Seal Installer As Per Dwg RBW6305G17931-3G Rev. B	Firmed	4/9/18	3 Ea	0 Ea	3 Ea	\$392.72/Ea	\$1,178.16
							✓ 3x			AT 18/04/16	
Line Item Note job# 172377											
30	RBW6305G17131-3GP			Drive Quill Seal Housing Removal Tool As Per Dwg RBW6305G17131-3G Rev. 3	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$905.64/Ea	\$2,716.92
							✓ 3x			AT 18/04/26	
Line Item Note job# 172376											



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 039084

Dated: 04/27/2018

Our Order / Job No:08AWT

Order Qty: 3

Part Name: Tool, Gimbal Carbon Seal Installer

Part Number: RBW6305G13231-3G

Lot Size:N/A

Ship Date: 04/27/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6305G13231-3G

Rev:B

Material Size and Type: -1/6061 ALUM.; -3/6061 ALUM.; -5/ 6061 ALUM; -7/ 6061 ALUM

Material Specifications: ALUM.: ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

04/27/18

Signed:

DAS
38
9-88

MAY 02 2018

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